

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003371**Date Inspected:** 24-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Chih-Ming/Li Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG side, bottom and deck panels and tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:
OBG bay 7

QA performed 10% verification Ultrasonic Testing (UT) on the following floor beam weld: FB-009-001-043. All welds that were scanned appeared to comply with AWS D1.5 2002 and the contract documents.

QA observed ZPMC UT technicians UT the following floor beam welds: FB-028-127 and FB-039-127. Both of the welds were rejected by ZPMC.

QA observed ZPMC personnel removing five stiffeners from each of the following floor beam webs by carbon arc gouging: FB-028, FB-027 and FB-039. Reason for the removal is unknown by QA at this time.

QA observed ZPMC Magnetic particle Testing (MT) technicians MT'ing stiffener to web fillet welds on floor beam FB-009. MT was not completed before QA departed the area.

OBG new assembly bay 2

QA performed 10% verification Ultrasonic Testing (UT) on side panel welds: SP-358-001-016, 018, 020, 022 and 024, SP-331-001-016 and 018. All welds examined appeared to conform to AWS D1.5 2002 and the contract documents.

QA observed ZPMC qualified welding personnel FCAW root SEG-026A-008 OBG section 5CE following the guide lines of WPS-B-T-2231-B-U2-F-1. QC monitored the welding process continuously throughout the evening.

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The welder ID and welding parameters as measured with Quality Controls calibrated instruments appeared to be in conformance with the posted WPS's and were as follows:

Volts: 30.5 Amps: 285 Travel Speed: 495

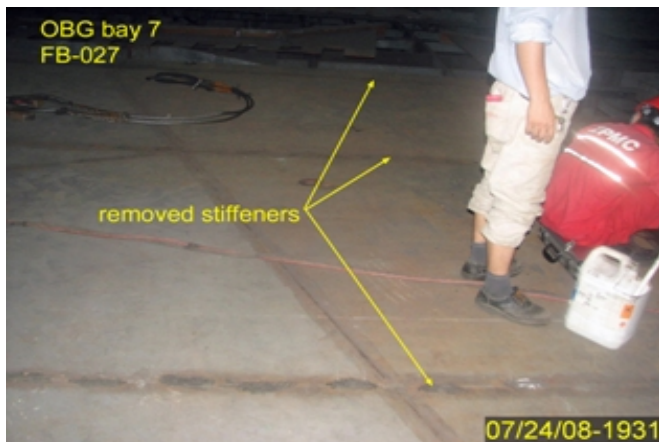
Welder ID: 044795

QA observed ZPMC qualified welding personnel SMAW tack welding SEG-017-002 DP-260 to DP-270.

QA observed ZPMC personnel fitting diaphragm plates inside corner assembly. No part ID found.

QA observed ZPMC personnel fitting component LD-3A W3 between PP-027 and PP-026 on OBG section 4BW.

Other general observations include ZPMC personnel fitting and welding OBG east fixture, OBG temporary support columns, grinding and weld bevel prep on various OBG components.



Summary of Conversations:

Only general conversations were held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

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Inspected By:	Hall,Steven	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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